Work Order ID 63515

Wednesday, November 03, 2010 11:14:35 A

Item ID: D3272-1 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Step

Start Date: 11/3/2010 **Start Qty:** 10.00 **Cust Item ID:**

Required Date: 12/8/2010 **Req'd Qty:** 10.00 **Customer:**

Reference:

Approvals: **Process Plan:** M **Date:** 10-11-03 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3272	Rev B								
100		0.00							
Large Fab	Large Fab								
Large Fab	**Memo**	0.00							
	SQUARE ONE END BEFORE CUTTING OTHER END								
	1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A								
	2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.								
	3-Deburr								
110	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control									

10.12.06 10 0

8/11/12/06 10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Identify as per dwg & Stock Location: WH	0.00							
Packaging			10-12-06			10	0		
Packaging	**Memo**	0.00							
130	QC21- Final Inspection - Work Order Release	0.00							
QC						CK	10/12/06		
Quality Control	**Memo**	0.00							

MF 10-12-06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Wednesday, November 03, 2010 11:14:39 AM

Work Order ID: 63515

Parent Item: D3272-1

Parent Item Name: Step

Start Date: 11/3/2010 **Required Date:** 12/8/2010

Start Qty: 10.00 **Required Qty:** 10.00

Comments: IPP Rev:A New Issue 07-06-09 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C Step Extrusion		Manufactured	No			100	Each	113.8200	1	10			

10-12-06

Location	Loc Qty	Loc Code	
WA	113.82		
55214	3.42		
58544	9		
61208	101.4		10

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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NOTE: Date & initial all entries

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS

A	04.03.01	NEW ISSUE
B	07.05.18	D3272-1 WAS D2622-120

RELEASED
07 06 04

	QTY -041	QTY -042	PART NUMBER	DESCRIPTION
	X		**D3272-041**	**STEP ASSEMBLY, HIGH LONG (LH)**
		X	**D3272-042**	**STEP ASSEMBLY, HIGH LONG (RH)**
	1	1	D3065-041	LEG ASSEMBLY
	2	2	D3066-1	SPACER
	2	2	D3067-1	END PLATE
	2	2	D3219-1	SUPPORT
B	1	1	D3272-1	STEP
	16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
2) WELD PER DART QSI 004
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
 BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 625515

BS 10-11-03

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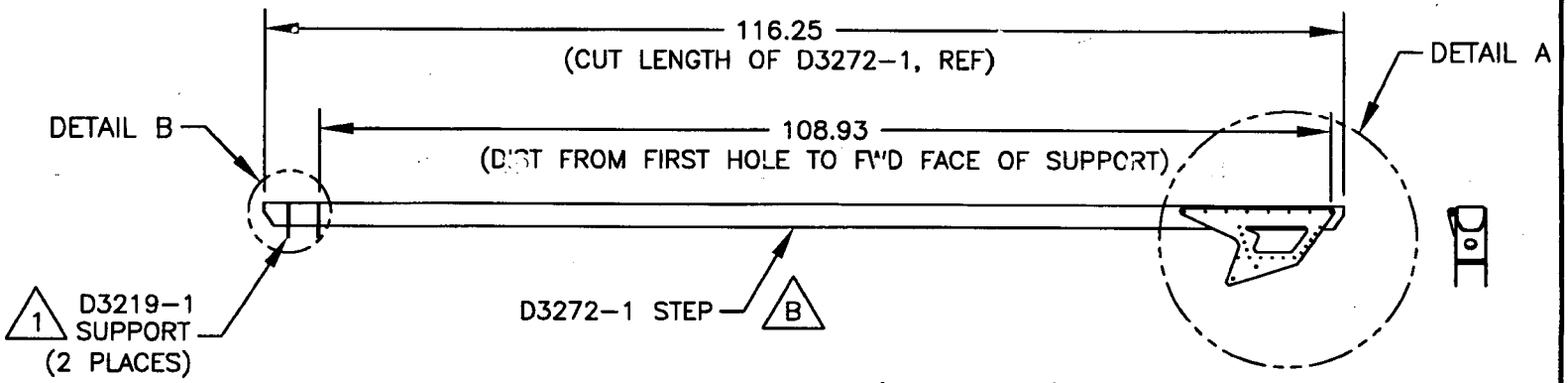
W/O:		WORK ORDER CHANGES					
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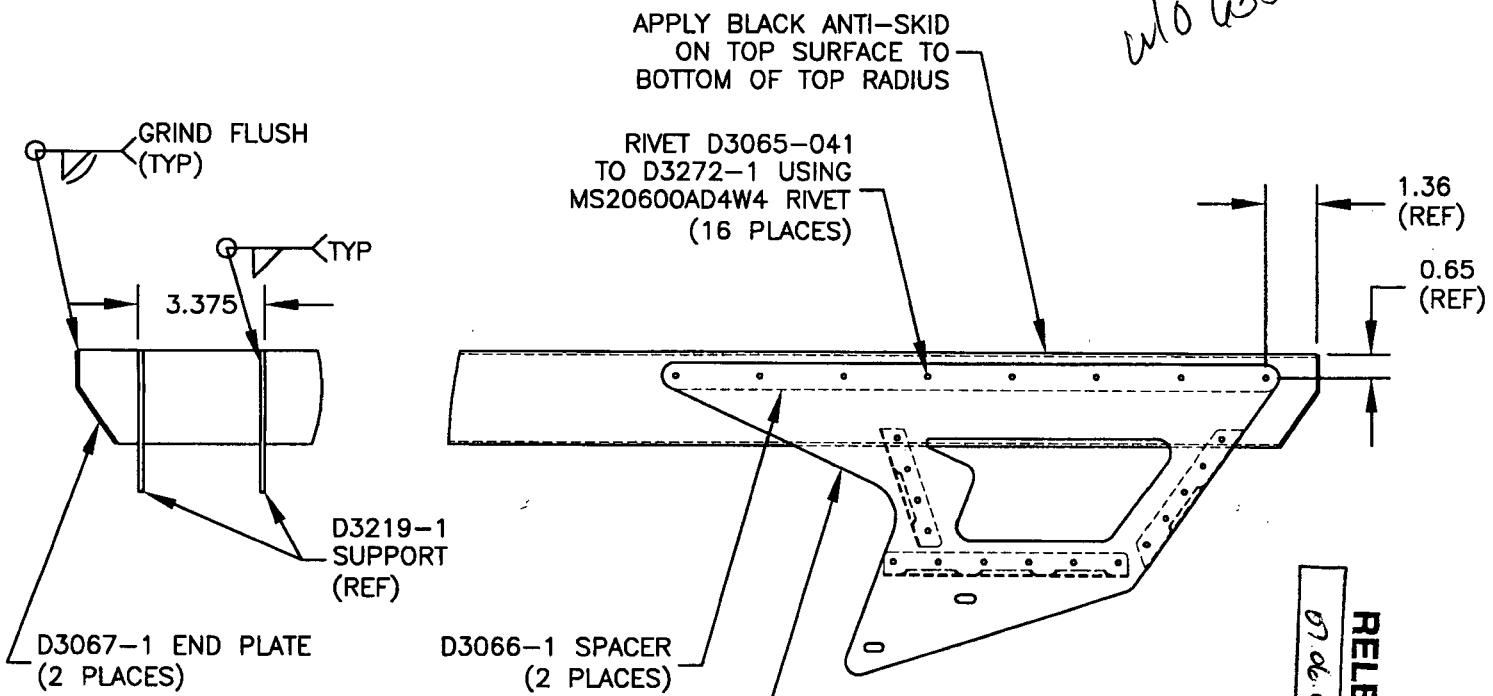
NOTE: Date & initial all entries



D3272-041 STEP ASSEMBLY (LH, SHOWN)

D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

w/o 63515



DETAIL B
(SCALE 1:5)

DETAIL A
(SCALE 1:5)

RELEASED
07 de 04

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	REV. B
DATE 07.05.18		DRAWING NO. D3272	SHEET 2 OF 3
		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

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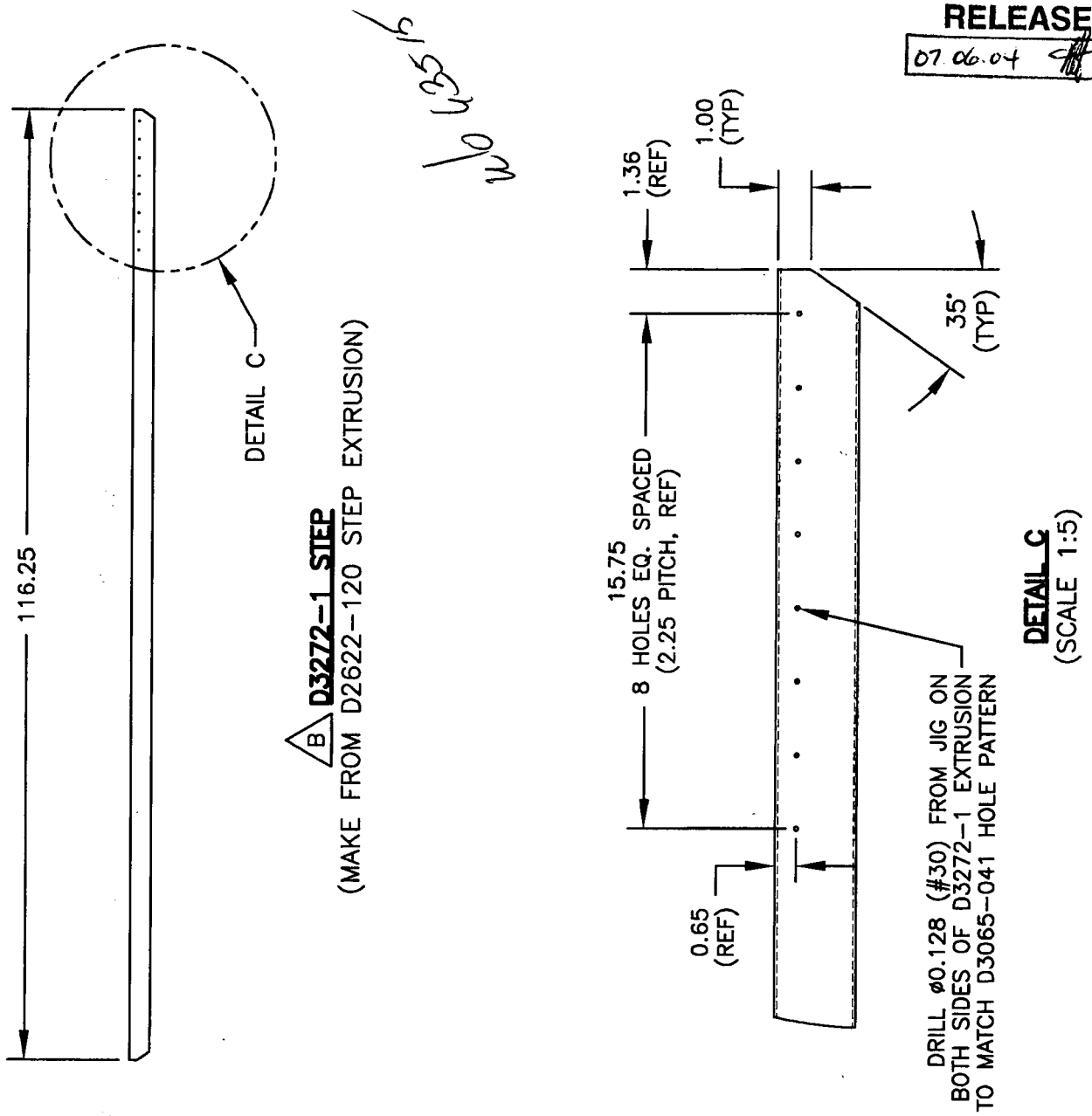
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED
07.06.04



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